

Work Order ID 104723

104723

Page 1

July-17-13 9:23:29 AM

Item ID: D4635-4

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Ceiling Panel, RH

Start Date: 7/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-07-17 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4635

C

100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x/

DAS
07
9-89

13/07/16

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 KYDEX

Temp: 150 FTime IN: 2:00 pm 13/07/15Time OUT: 7:00 am 13/07/16

x/

DAS
07
9-89

13/07/16

104723

July-17-13 9:23:29 AM

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 104723

104723

Page 3

July-17-13 9:23:29 AM

Item ID: D4635-4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Ceiling Panel, RH

Start Date: 7/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Used For D4635-145
B 104788

13/08/07

MLJ 13-08-12

Qpl 13-8-8

35

Picklist Print

July-17-13 9:23:28 AM

Page 1

Work Order ID: 104723
 Parent Item: D4635-4
 Parent Item Name: Aft Ceiling Panel, RH

Start Date: 7/17/13 Required Date: 7/25/13
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update
 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ MKYD6185S.080-P3- 52068 Kydex steel grey		Purchased	No			100	sf	2,255.4554	8.49	9.4333333			

Location	Loc Qty	Loc Code
therm	2255.455401	
119476	120.100001	
121902	1060.697	
122181	1074.6584	

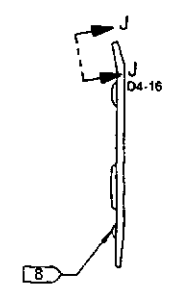
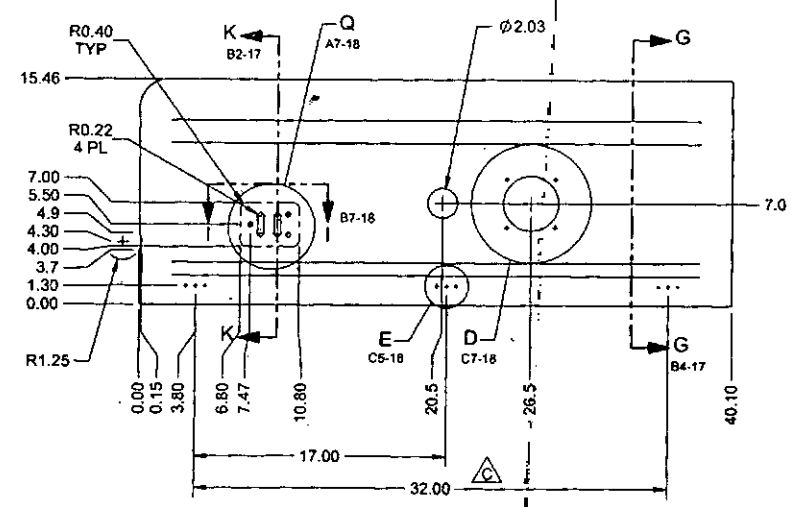
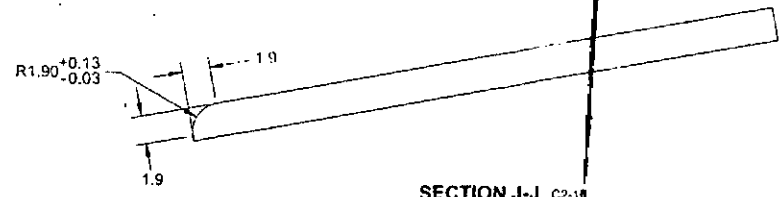
9.44 58 ft

DL
 13/08/01

1307-12

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4635 TITLE OUTBOARD CEILING PANELS SCALE NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRINTED BY AND FOR THE COMPANY, AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS FOR ANY PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. PRINTED AND MANUFACTURED IN CANADA BY DART AEROSPACE LTD.</small>	REV. C
DRAWN	RF		SHEET 15 OF 18
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DE APPR.	<i>RE</i>		
DATE	13.06.18		

104723



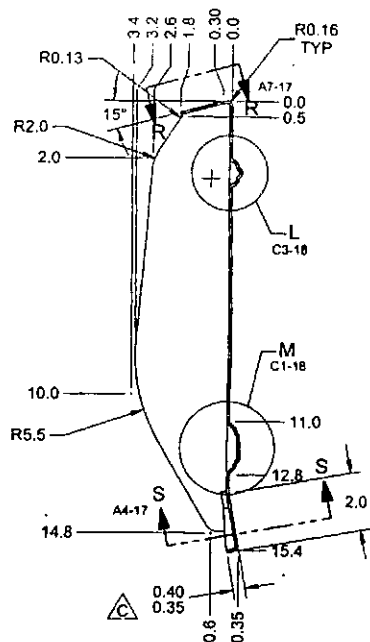
- NOTES:**
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 PER DART SPEC MKYD6185S.080-P3-52068
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.60 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) TRIM D4635-4 PER TOOL DT9842
 - 10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-4 RH, AFT CEILING PANEL

RELEASED
2013-07-15

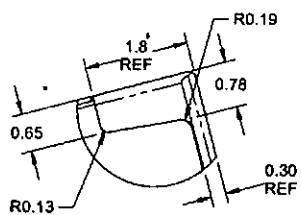
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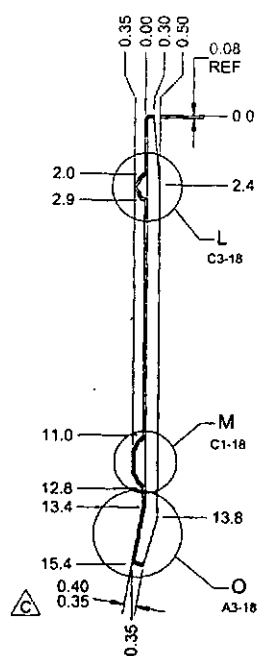
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SECTION A-A' OPPOSITE
SCALE 2X

B3-13
B3-14



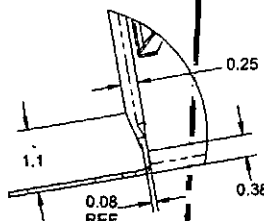
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SECTION R-R' OPPOSITE
SCALE 2X

D7-17



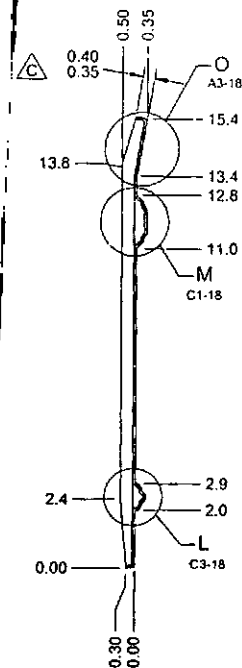
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B7-13
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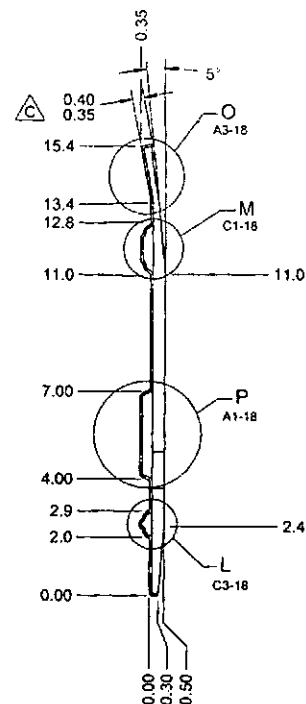
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SECTION S-S' OPPOSITE
SCALE 2X

B7-17



SECTION G-G
SCALE 2X

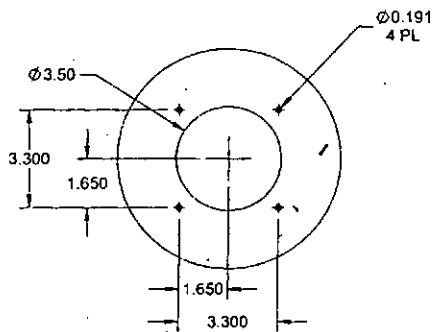
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B4-16



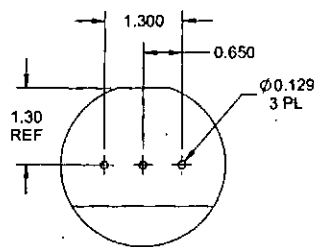
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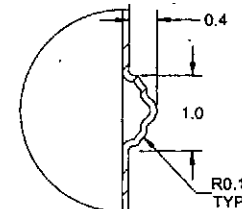
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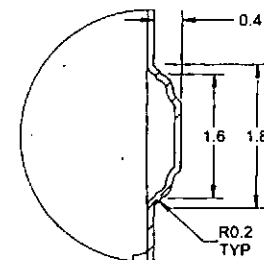
DETAIL D
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B4-13
B3-14
B5-15
B5-16



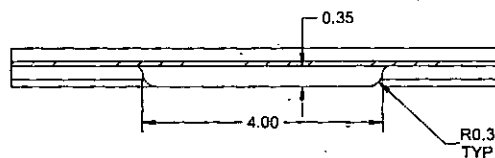
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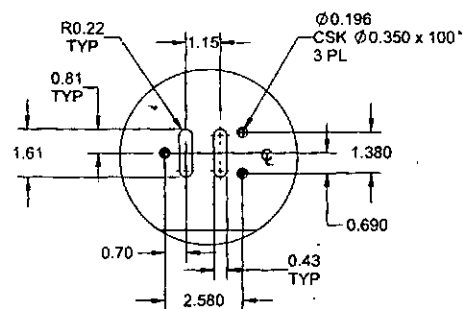
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C7-17



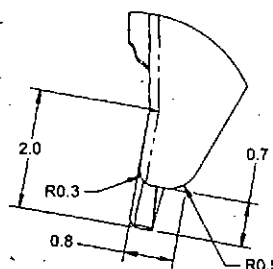
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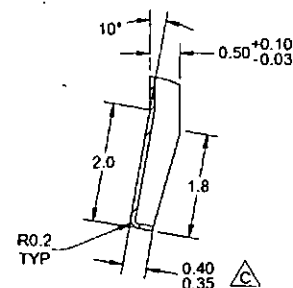
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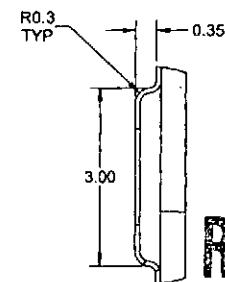
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DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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